

# Work Order ID 51905

Wednesday, September 09, 2009 11:10:24 A



Page 1

Item ID: D3564-11 *6Y* Accept

Revision ID: D

Item Name: Wearshoe

Start Date: 9/11/2009 Start Qty: 8.00

Required Date: 9/11/2009 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: *BL m* Date: *09-9-09* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3564	Rev D								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

*304 .063*

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\* ☐ Dwg Rev: *D* ☐ Prog  
Rev: *D* ☐ 2-Deburr if necessary

*B 9-10-5*

*(11)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B 9-10-5*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*27 8/21/05*

*(11)*

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Item ID:	D3564-11	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Wearshoe					
Start Date:	9/11/2009	Start Qty:	8.00		Cust Item ID:	
Required Date:	9/11/2009	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00				11	8		
Brake NC	Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3564 using Jigs DT8179								
									SB 09/10/07
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				710	1		
Quality Control									
150 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch <input type="checkbox"/> A/R 2059B Hardcoat								
	<del>1</del> Weld hardcoat as per Dwg D3437								
	M172272								
						PD	09.10.08		11

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Item ID: D3564-11

Revision ID: D

Item Name: Wearshoe

Start Date: 9/11/2009 Start Qty: 8.00

Required Date: 9/11/2009 Req'd Qty: 8.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

27 Sorholoe

(X4)

4

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 Sorholoe

(X1)

4

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

START TIME:

7:15

OVEN TEMPERATURE:

380° FINISH TIME:

7:45

109091  
12-09-10-9

(11)

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Item ID: D3564-11

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 9/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 9/11/2009 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	ll 09/10/09			(XII) 0			
200  Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-19</u>  Memo	0.00 0.00	ll 09/10/09			(XII) 0			
210  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							09/10/13

ll 09/10/09

# Picklist Print

Wednesday, September 09, 2009 11:10:31 AM

Page 1

Work Order ID: 51905

Parent Item: D3564-11RevD

Parent Item Name: Wearshoe



Comments:

Start Date: 9/11/2009

Required Date: 9/11/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	261.2310	11.8737	16.3263		
304/316 Sheet .063											18 9-10-5	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

261.2309737

106860

16.018

111924

33.0549737

112290

36.8947

112442

79.2633

112567

96

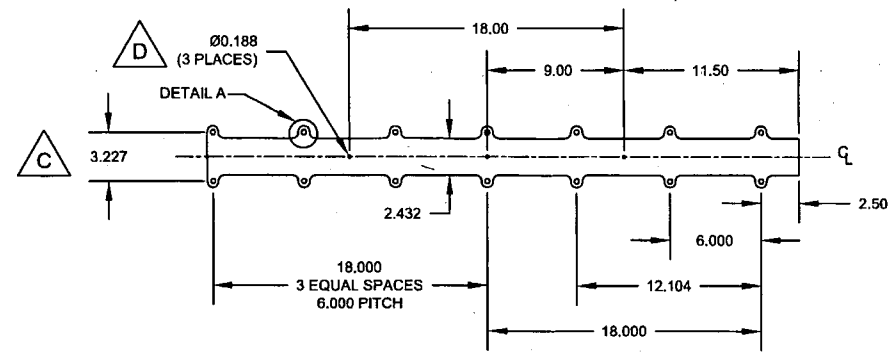
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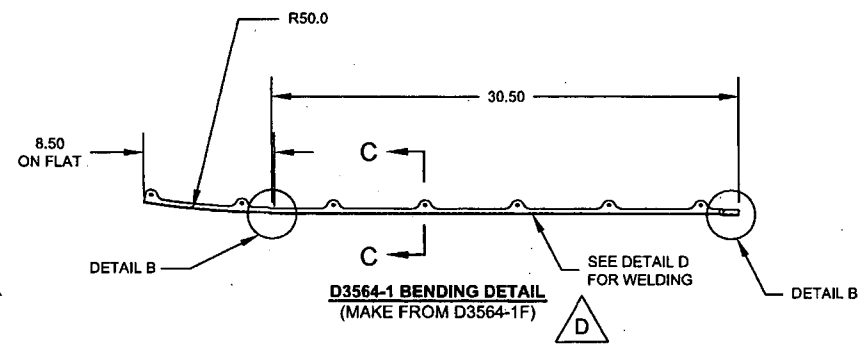
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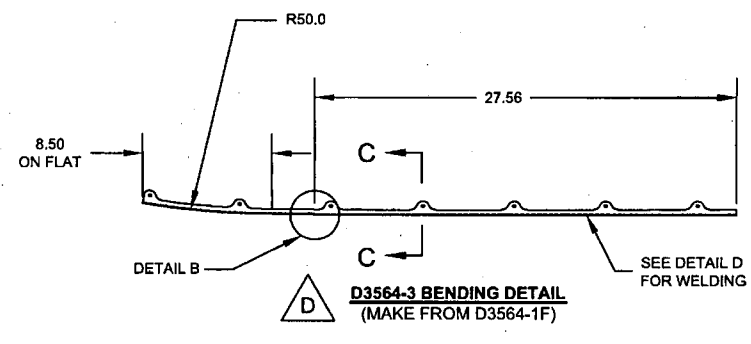
07.09.04



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL  
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL  
(MAKE FROM D3564-1F)

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

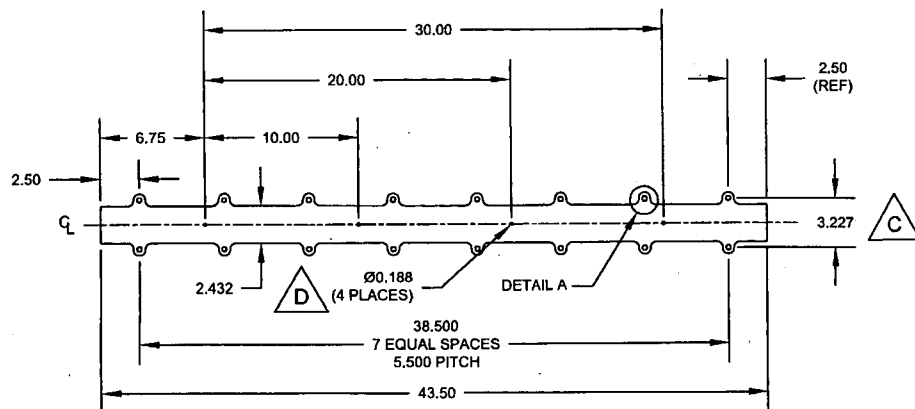
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

**WEIGHTS:**

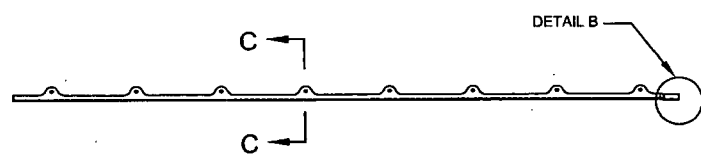
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. D3564 REV. D SHEET 1 OF 3 TITLE WEARSHOE SCALE 1:8  COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

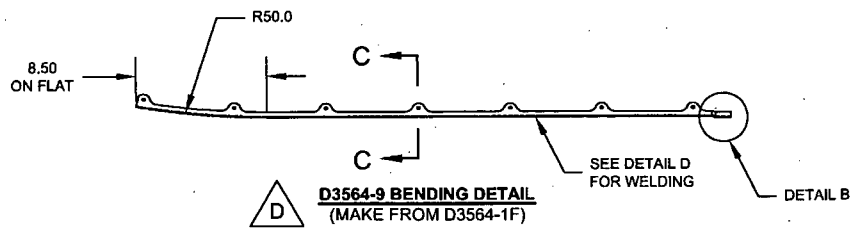
8 7 6 5 4 3 2 1



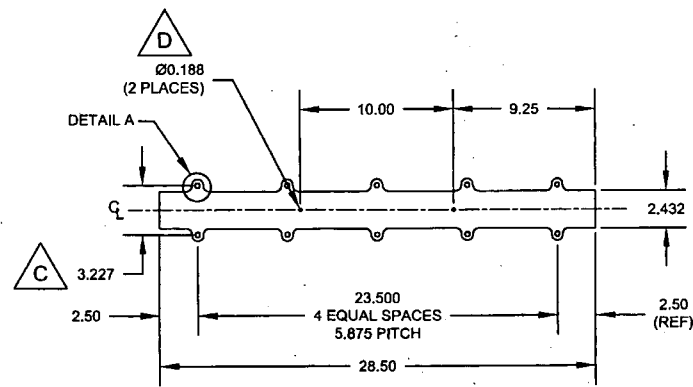
**D3564-5F FLAT PATTERN**



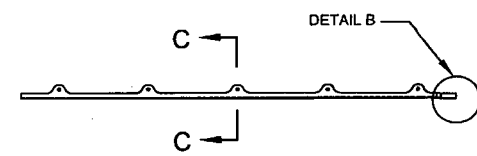
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



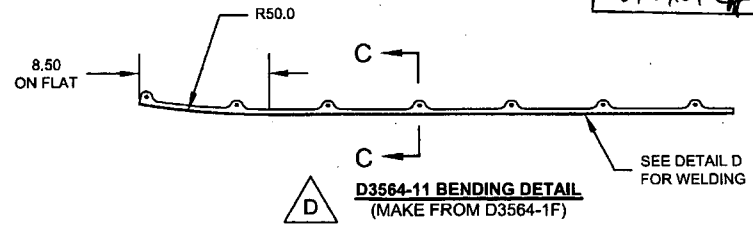
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

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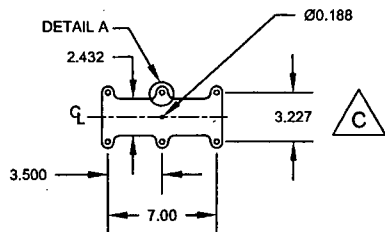
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MFG. APPR.	PH	D3564	SHEET 2 OF 3
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DE APPR.	PH	WEARSHOE	1:8
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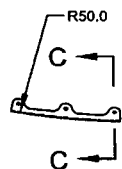
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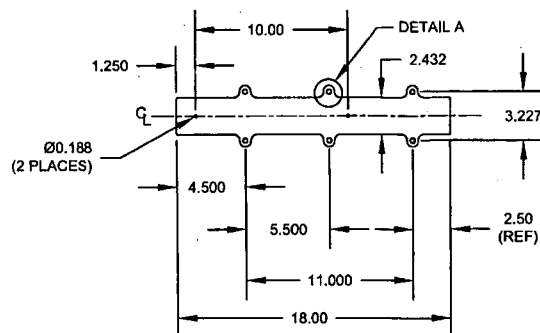
8 7 6 5 4 3 2 1



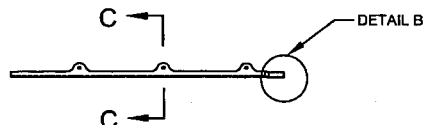
**D3564-13F FLAT PATTERN**



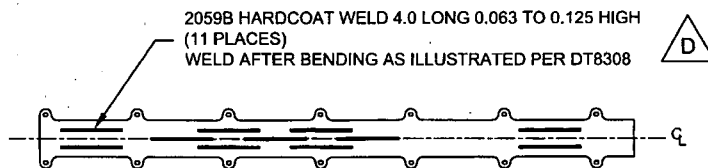
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**D3564-15F FLAT PATTERN**



**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)

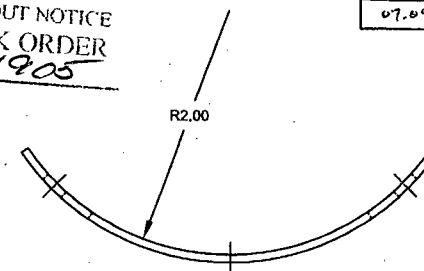


**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)

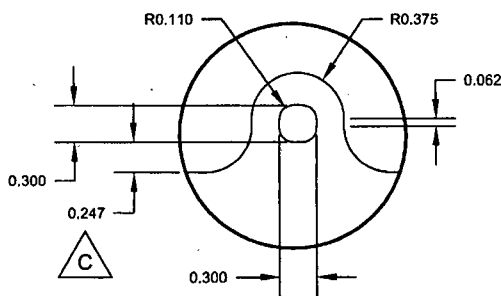
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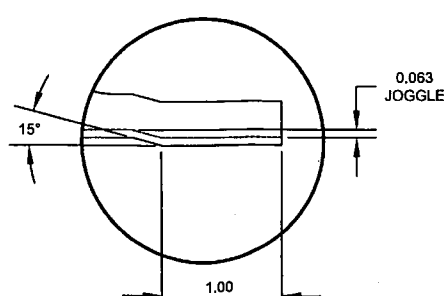
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**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

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8 7 6 5 4 3 2 1